

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021965**Date Inspected:** 01-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector randomly observed the following work in progress in the Bay 14:

SMAW repair welding of weld joints DP3171-001-240, 241, 318 located on PCMK OBG 14W. Welder was identified as 037780. QC was identified as ZPMC CWI Li Mingyang (QC1). Weld variables recorded by QC1 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1 and WPS-345-SMAW-3G(3F)-FCM-repair-1 as verbally identified by QC1. QC1 informed this QA Inspector that the repairs were the result of ZPMC visual testing (VT).

SMAW repair welding of weld joint DP3172-001-036 located on PCMK OBG 14W. Welder was identified as 067588. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhu Lin (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-WR20289 presented to this QA Inspector and verbally identified by QCA1.

FCAW welding of weld joint SEG3020L-075 located on PCMK OBG 14W. Welders were identified as 045175. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with

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WPS-B-T-2232-ESAB as verbally identified by QCA1.

FCAW welding of weld joints SEG3020S-123, 124 located on PCMK OBG 14W. Welders were identified as 067949. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

SMAW welding of weld joint FB3316-001-011 located on PCMK OBG 14W. Welder was identified as 067609. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-FCM-1 as verbally identified by QCA1.

FCAW welding of weld joint SEG3013D-232 located on PCMK OBG 13AW. Welder was identified as 045143. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1.

FCAW welding of weld joint SEG3013B-255 located on PCMK OBG 13AW. Welders were identified as 066421, 067876. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1.

FCAW welding of weld joint SEG3013E-226 located on PCMK OBG 13AW. Welders were identified as 069469, 203871. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1.

FCAW welding of weld joint SEG3013P-061 located on PCMK OBG 13AW. Welder was identified as 068445. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA1.

FCAW welding of weld joint SEG3013M-035 located on PCMK OBG 13AW. Welder was identified as 067876. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

SMAW welding of weld joint SEG3013F-048 located on PCMK OBG 13AW. Welder was identified as 066038. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-B-FCM as verbally identified by QCA1.

SMAW welding of weld joint SEG3013H-038 located on PCMK OBG 13AW. Welder was identified as 067864. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation

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and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-B-FCM as verbally identified by QCA1.

SMAW welding of weld joint SEG3013K-047 located on PCMK OBG 13AW. Welder was identified as 067764. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2214-B-FCM as verbally identified by QCA1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley, Ken
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QA Reviewer
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